

ABSTRACT

A heat treatment operation can be executed, suppressing a wave-shaped deformation at a non heat-treatment region of an article to be heat treated.

To an elongated-shaped article to be heat treated (10) to which a raised portion (11) extending in the longitudinal direction is formed, a hardening region as being a heat-treated region defined to be extended in a longitudinal direction at a part of the raised portion (11) and a non-hardening region as being non heat-treated region defined to be extended in the longitudinal direction at flange portion (13) and other parts of the raised portion (11) are arranged side by side in a width direction orthogonal to the longitudinal direction. The flange portion (13) is clamped by a first and a second clamping means (22), (23) arranged in the longitudinal direction, and one first clamping means (22) is a tight clamping means holding fixedly the flange portion (13) and a plurality of second clamping means (23) are loose clamping means clamping loosely the flange portion (13), allowing the article to be heat treated (10) to be convex on the side of the heated hardening region.